



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4880-041
Job Sheet 187757



Part No: D4880-041

Job Qty: 4 pcs

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	4 pcs	1/11/19	0.00	2.20		Small Fab - 1		DAS 58 MAY 09 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	4 pcs	1/11/19	0.00	0.00		QC 5 - 10		DAS 40 MAY 10 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Small Fab - 2 - B4B	4 pcs	1/11/19	0.00	2.20		Small Fab - 1 - B4B		DAS 58 MAY 10 2019 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		

				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	4 pcs	1/11/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				DAS MAY 13 2019 40 9-89	
180 Packaging 3-1 - Stock - B4B	4 pcs	1/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				DAS 28 9-89	
190 QC 21 - SA	4 pcs	1/11/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				DAS 21 MAY 13 2019	
Part Op 110 - Small Fab - ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH					
Plex 1/29/19 2:59 PM Dart.Hadley.Shannon					

Descriptions: HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9971 AS PER DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Small Fab 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R HYSOL BATCH: 5080785 2- LASER ENGRAVE PART# AND SERIAL # AS PER DWG

140 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - Identify as per dwg & Stock Location: _____

009452

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	2, 4 pcs (1 ea)	110-Small Fab - 1	5150394
D4883-7	End Fitting	2, 4 Ea (1 ea)	110-Small Fab - 1	5140145
D4884-1	End Fitting, Eye	2, 4 pcs (1 ea)	110-Small Fab - 1	5176902
HL32PB5-12	Hi-Lok Pin	8, 16 Ea (4 ea)	110-Small Fab - 1	5144141
HL86-5	Hi-Lok Collar	8, 16 pcs (4 ea)	110-Small Fab - 1	5120513

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4880-1	4	2	0
	D4883-7	4	6	0
	D4884-1	4	10	0
	HL32PB5-12	16	100	0
	HL86-5	16	81	0

Part Specifications

Specifications could not be found.

Plex 1/29/19 2:59 PM Dart.Hadley.Shannon



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	4 pcs	1/11/19	1/11/19	0.00	2.20	Small Fab-8		
120	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
130	Small Fab	4 pcs	1/11/19	1/11/19	0.00	2.20	Small Fab-8		
140	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
180	Packaging	4 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		
190	QC21-SA	4 Ea	1/11/19	1/11/19	0.00	0.00	QC21		

Part Op 110 - ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9971
AS PER DWG.
130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R
HYSOL BATCH: _____ 2- LASER ENGRAVE PART# AND SERIAL # AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	4 Ea (1 ea)	90-Start up Operation	
D4883-7	End Fitting	4 Ea (1 ea)	90-Start up Operation	
D4884-1	End Fitting, Eye	4 Ea (1 ea)	90-Start up Operation	
HL32PB5-12	Hi-Lok Pin	16 Ea (4 ea)	90-Start up Operation	
HL86-5	Hi-Lok Collar	16 pcs (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4880-1	4	5	0
	D4883-7	4	0	0
	D4884-1	4	1	0
	HL32PB5-12	16	50	0
	HL86-5	16	101	0

Part Specifications

Specifications could not be found.

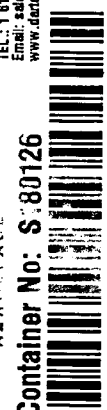
Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Description Wo  Container No: S:80126 Part: D4880 - 041 Job No: 187757 Serial No/Ratch: S180126 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 05/10/19			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐					MRB (QSI042)
					Completed By Lead hand / Supervisor QC / QA Coordinator
Other/Details: _____		☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Wrong _____ Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			